

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002348**Date Inspected:** 08-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M, Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Closed Rib Deck Panel	NA	NA	Welding

OBG Bay 1: Caltrans QA observed ZPMC shop workers performing fitup and tack welding, closed u-ribs to deck plate, assembly identified as DP248-001. The tack welders were identified as Mr. Tang Ke, welder stamp #062305 and Mr. Sheng Shi Zhen, welder stamp #059401, utilizing welding procedure WPS-B-T-2342-U2 (rib), revision 0. Caltrans QA also observed the welding the of closed u-rib complete joint penetration (CJP) splice weld, subassembly u-rib identified as DP462-001-190 and 191. The welder is identified as Mr. Song Yin Shu, welder stamp #059421, utilizing welding procedure WPS-B-T-2233-B-U2-F, revision 1. Caltrans QA observed ZPMC QC/CWI inspector, Mr. Chen Xi monitoring the welding activities at the workstations. The following digital picture illustrates fitup and tack welding closed rib to deck plate.

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- 2 Tower Skin Plate NA NA Mechanical Straghtening
- New Tower Shop Bay 3: Caltrans QA observed ZPMC mechanical straightening of the tower longitudinal skin plate stiffener, identified as P352 A (E). The plate is being straightened at the 3000 ton press. Caltrans QA observed ZPMC QC inspector, Mr. Shi Yu monitoring the straightening of the tower plate. The following digital picture illustrates mechanical straightening of the longitudinal stiffener plate.



- 3 Closed Rib Deck Panel NA NA Welding
- OBG Bay 1: Caltrans QA Inspector observed the welding of deck panel DP437-001 weld 003, 004, 007 and 008. ZPMC welder are observed welding submerged arc welding (SAW) cover pass welds, utilizing welding procedure specification WPS-B-T-2342-U1 (Urib)- 3. The welder operators are identified as Mr. Xiang Jie, welder stamp 059378, Mr. Xiang Huan Feng, welder stamp 059416, Mr. Chen Jie, welder stamp 059468 and Mr. Zhong Shao hui, welder stamp 059403. Caltrans QA measured current welding parameters at approximately 690 amps, 29.5 volts and 515mm/min (millimeters per minute) travel speed. Caltrans QA observed ZPMC QC/CWI inspector, Mr. Che Xi monitoring the activities at welding gantry #2 work station. The following digital picture illustrates welding in progress.

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Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler,Mike	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
